

Date: Wednesday, 1/31/2007 2:40:05 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LONG STEP ASSEMBLY HIGH SKID LH
Job Number : 30522	
Estimate Number : 10270	
P.O. Number : <i>N/A</i>	Part Number : D350591311
This Issue : 1/31/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3272 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 30462	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 3/15/2007 Qty: 10 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev. A 04.03.22 New issue KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

KS 07.02.16

2.0	D2622120C	Extrusion
-----	-----------	-----------



Comment: Qty.: 1 Each(s)/Unit Total : 10 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2622-120

Extrusion

*B30199**SE 07.04.16**10*

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A

*SE 07.04.16**10*

2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.

*SE 07.04.16**10*

3-Deburr

*SE 07.04.16**10*

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

SE 07.04.16

5.0	D30671	End Plate
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Comment: Qty.: 1 Each(s)/Unit Total : 10 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3067-1

End Plate

*B30143**330559 = 9**11**SE 07.04.16**10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/31/2007 2:40:06 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 30522

Part Number: D350591311

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

D32191

Support



Comment: Qty.: 2 Each(s)/Unit Total: 20 Each(s)

Pick:

Qty Part Number

Description Batch

2 D3219-1

Support

330468-20

(+5 left)

SE 07.04.16

10

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel end for welding FWD ONLY

SE 07.04.16

10

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod M100237

M100317

SE 07.04.17

10

3-Grind End Plate flush

SE 07.04.17

10

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/04/17 (10)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07.04.17 (10)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-L

07/04/18

(10X)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SE 07.04.23

10

12.0

D3065041

Step Leg Assembly



Comment: Qty.: 1 Each(s)/Unit Total: 10 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3065-041

Step Leg Assy

330466

SE 07.04.23

10

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 30522

Part Number: D350591311

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D30661

Spacer



Comment: Qty.: 2 Each(s)/Unit Total : 20 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3066-1

Spacer

330467 = 19
330767 = 1

PK. 07.04.23 10

14.0

MS20600AD4W4

Rivets



Comment: Qty.: 16 Each(s)/Unit Total : 160 Each(s)

Pick:

Qty Part Number

Description

Batch

16 MS20600AD4W4

Rivet

M103481

PK. 07.04.23 10

15.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1.

Assemble Leg Assembly as per Dwg D3272.

Leave one rivet out until welding is complete.

PK. 07.04.23 10

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PK. 07.04.24 LH
(10)

17.0

D30671

End Plate



Comment: Qty.: 1 Each(s)/Unit Total : 10 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3067-1

End Plate

330559

PK. 07.04.24 10

18.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1.

1-Bevel Aft end for welding

2-Inspect for foreign object as per QSI 024

3-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod M102756

PK. 07.04.24 10

PK. 07.04.24 10

PK. 07.04.24 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 30522

Part Number: D350591311

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Grind End Plate flush

FF 07.04.24 (3) / 07.04.24 (10)
PL 07.04.24 (10)

5-Install last rivet as per Dwg.

19.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/04/24 (10)

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07.04.24 (10)

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

touch up alodine

HL 07-04-27 (10)

22.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M103706

HL 07-04-30 (10)

23.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3272 and QSI 005 4.4

M103707

FL 07/04/30 (10)

24.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

PL 7/5/01 (10)

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

26.0

D22303

Mounting Lug



Comment: Qty.: 4 Each(s)/Unit Total : 40 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2230-3 Mounting Lug

B30273✓

7/4/3080

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 30522

Part Number: D350591311

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

D2618

Bushing



Comment: Qty.: 2 Each(s)/Unit Total : 20 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2618

Bushing

* (5) ✓
B29645 ✓

15 ✓
B30465-U ✓

28.0

D2856400

Abrasion Strip



Comment: Qty.: 1 f(s)/Unit Total : 6 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2856-400-720 Abrasion Strip

B29850- ✓

29.0

D32351

Mounting Lug



Comment: Qty.: 2 Each(s)/Unit Total : 20 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D3235-1

Mounting Lug

B30050 ✓

30.0

D3278041

Support Assembly



Comment: Qty.: 1 Each(s)/Unit Total : 10 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3278-041 Support Assembly

1 D3272-041(ref) Step Assembly

(2x) ✓
B30276 - B29647 (8X) ✓
B30522

31.0

AN335A

Bolt



Comment: Qty.: 2 Each(s)/Unit Total : 20 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN3-35A

Bolt

M102339 ✓

7/4/30 59 -

32.0

AN413A

Bolt



Comment: Qty.: 8 Each(s)/Unit Total : 80 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 30522

Part Number: D350591311

Job Number:



Seq. #:

Machine Or Operation:

Description :

8 AN4-13A

Bolt

M103363 ✓

33.0

AN536A

Bolt



Comment: Qty.: 2 Each(s)/Unit Total : 20 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN5-36A

Bolt

M104093 ✓

M103154 ✓

34.0

AN960JD10

Washer



Comment: Qty.: 4 Each(s)/Unit Total : 40 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10

Washer

M103962 ✓

M100743 ✓

35.0

AN960JD416

Washer



Comment: Qty.: 16 Each(s)/Unit Total : 160 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 AN960JD416

Washer

M102969 ✓

36.0

AN960JD516

Washer



Comment: Qty.: 4 Each(s)/Unit Total : 40 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD516

Washer

M103642 ✓

37.0

MS21042L3

Nut



Comment: Qty.: 2 Each(s)/Unit Total : 20 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L3

Nut (or -3)

M103585 ✓

7/4/30 SCD

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: Q Date: 07/05/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 30522

Part Number: D350591311

Job Number:



Seq. #:

Machine Or Operation:

Description :

38.0

MS21042L4

Nut



Comment: Qty.: 8 Each(s)/Unit Total : 80 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4

Nut (or -4)

M103914 ✓

39.0

MS21042L5

Nut



Comment: Qty.: 2 Each(s)/Unit Total : 20 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L5

Nut (or -5)

M102532 ✓

7/4/30 59

40.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

C207105101 (10)

20 7/5/01 (10)

41.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-311

Location:

Rev B

7/5/1 59 20

42.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

7/6/05/01

Job Completion



U 7/6/05/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3272	REV. A SHEET 1 OF 2
DATE 04.03.01		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	

RELEASED
04.04.05 *#*

Part No.	Description	QTY -041	QTY -042
D3272-041	Step Assembly, High Long (LH)	X	
D3272-042	Step Assembly, High Long (RH)		X
D2622-120	STEP EXTRUSION	1	1
D3219-1	SUPPORT	2	2
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

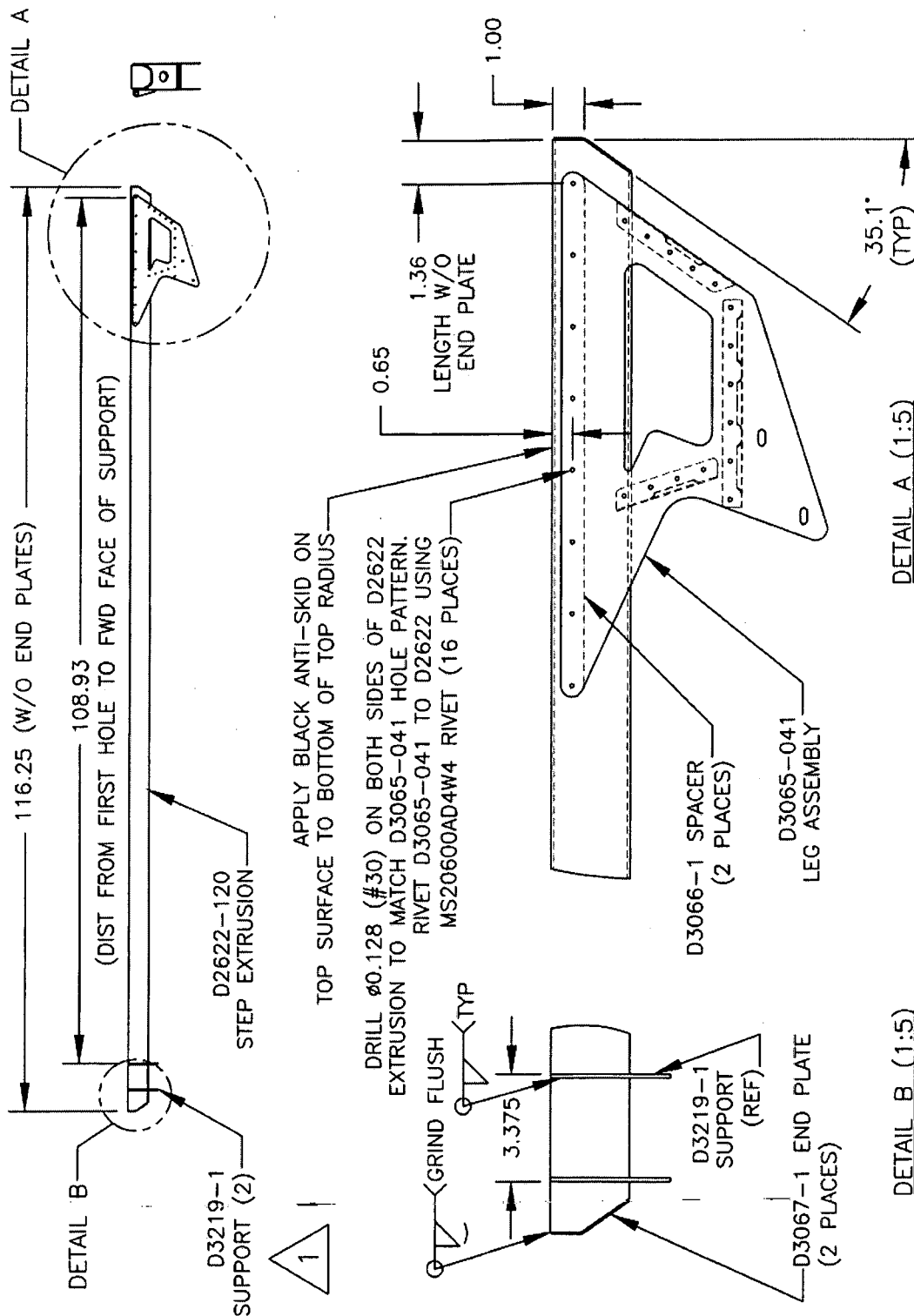
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				HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>#</i>	APPROVED	<i>#</i>	DRAWING NO. D3272
				REV. A
DATE	04.03.01	TITLE	STEP ASSEMBLY, HI LONG	SHEET 2 OF 2
				SCALE 1:20



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